



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4681-041
Job Sheet 190781



Part No: D4681-041

Job Qty: 4 pcs

Part Name: Web Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/14/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEETS 1,2 IPP REV:A 13.04.15 NEW ISSUE DD VERF:JLM IPP REV:B 13.08.08 PB1 DD VERF:JLM IPP REV:C 13.11.14 AS PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	4 pcs	3/18/19		0.00	3.45	Skidtubes - 1		TF
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
120	QC 6	4 pcs	3/18/19		0.00	0.00	QC 6 - 42		PD 19.03.19
							QC 6 - 9		
							QC 6 - 68		
							QC 6 - 61		
121	HAAS 4 Axis - B4B	4 pcs	3/18/19		0.18	2.63	HAAS - 1 - B4B		KT 19.03.15
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
122	QC 2	4 pcs	3/18/19		0.00	0.00	QC 2 - 1		KT 19.03.15
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		



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CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S154962



Part: D4681-041

Job No: 190781

Serial No/Batch: S154962

Revision: b

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/20/19

				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
123 QC 8	4	3/18/19	0.00 0.00	QC 8 - 12	2/19/03/16
	pcs			QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
130 Handfinish - 1-1 Chemical-B4B	4	3/18/19	0.00 1.12	Handfinish - 1 - 1 - B4B	2/19/03/21
	pcs			Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	

					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140 QC 7	4 pcs	3/18/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 6	
					QC 7 - 60	MBG
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
150 Skidtubes - 2 - B4B	4 pcs	3/18/19	0.00 3.45		Skidtubes - 1 - B4B	00
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
160 QC 5	4 pcs	3/18/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
170 Packaging 3-1 - Stock - B4B	4 pcs	3/18/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	DD
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 pcs	3/18/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-55

APR 01 2019

Part Op 110 - 1- CUT TO LENGHT AS PER DWG

Descriptions: 120 - (QC6- All purchased or subcontracted products)

121 - (HAAS CNC Vertical Machine), MILL AS PER DWG AND FOLIO FB186 DWG REV: AAAB FOLIOREV: AA DEBURR

122 - (QC2- Inspect parts off machine FAI/FAIB)

123 - (QC8- Inspect parts - second check)

130 - (Chemical Conversion Coat per QSI005 4.1)

140 - (QC7-Inspect Chemical Conversion Coat)

150 - INSTALL DOUBLER BY REVITING AND SEALING FAYING SURFACE WITH PROSEAL AS PER DWG A/R

PROSEAL: 5146134 exp! 10/19

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2963-125	105 I-Beam Extrusion	4 pcs (1 ea)	110-Skidtubes - 1	B156872
D4681-3	Doubler	8 pcs (2 ea)	150-Skidtubes - 2 - B4B	3162414
MS20470AD4-6	Rivet, Universal Head	356 Ea (89 ea)	150-Skidtubes - 2 - B4B	30536584

5147496X25

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2963-125	4	73	0
150-Skidtubes - 2 - B4B	D4681-3	8	1	0
	MS20470AD4-6	356	1,612	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	
Description: Web		Part Number:	D4681-041
Inspection Dwg: D4681	Rev: B	Page 1 of 1	

INSPECTION SHEET

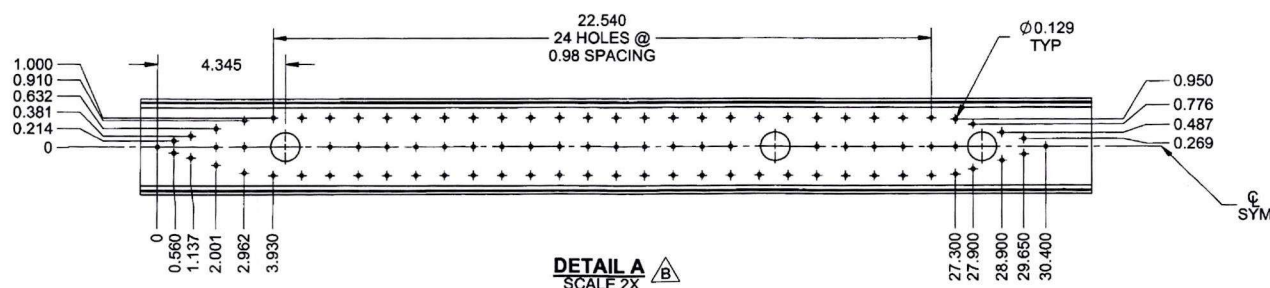
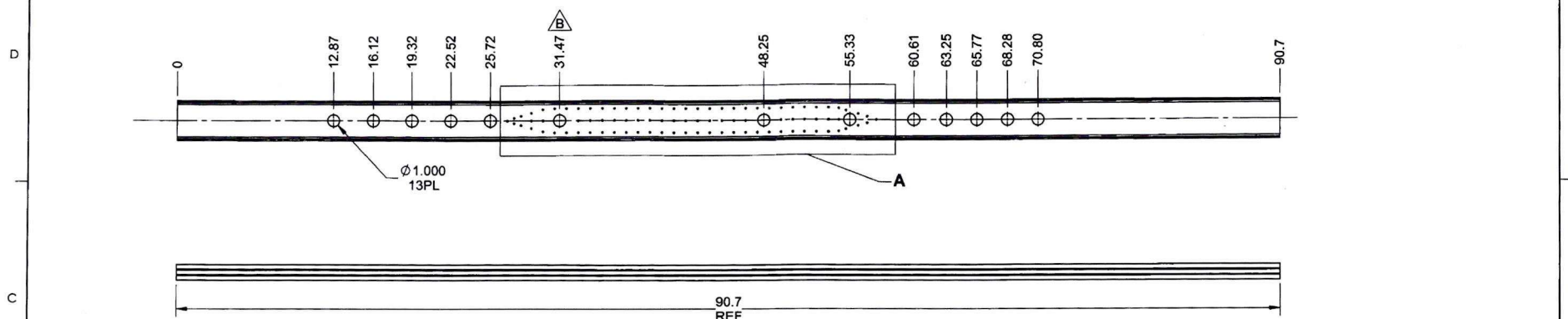
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
90.7	+/-0.100	90.7	✓		Tape	
12.87	+/-0.030	12.87	✓			
16.12	+/-0.030	16.12	✓			
19.32	+/-0.030	19.32	✓			
22.52	+/-0.030	22.52	✓			
25.72	+/-0.030	25.72	✓			
31.47	+/-0.030	31.47	✓			
48.25	+/-0.030	48.25	✓			
55.33	+/-0.030	55.33	✓			
60.61	+/-0.030	60.61	✓			
65.25	+/-0.030	65.25	✓			
65.77	+/-0.030	65.77	✓			
68.28	+/-0.030	68.28	✓			
70.80	+/-0.030	70.80	✓			
Ø1.000	+0.010/-0.001	1.005	✓		Vernier Pin gauge high gauge Vernier	
Ø0.129	+0.005/-0.001	0.129	✓			
1.000	+/-0.010	1.002	✓			
4.345	+/-0.010	4.345	✓			
22.540	+/-0.010	22.540	✓			
0.98	+/-0.030	0.981	✓			

Measured by: <i>MM</i>	Checked by: <i>mm</i>	QC Inspector:
Date: 2019/03/17	Date: 19/03/16	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	15.04.24	New Issue	KJ	<i>[Signature]</i>

8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: MAKE FROM D2963-092 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.74 lbs

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AP</i>	D4681	SHEET 2 OF 4
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>AP</i>	WEB ASSY	NTS
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2013-11-13

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